

Date: Tuesday, 07/10/2008 10:16:33 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 42492	
Estimate Number : 11873	
P.O. Number :	Part Number : D335315
This Issue : 07/10/2008 S.O. No. :	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34677	Material :
Written By :	Due Date : 25/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.10.07</u>	
Comment : est rev. A 06.01.14 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X0200	1010-1025 BAR .750 x 2.00
Comment: Qty.: 0.2520 f(s)/Unit Total : 2.5200 f(s) 1010-1025 BAR AISI 1010-1025 Steel bar 2.00" x 0.750" Batch: <u>M15925 ml 08/10/11</u> (10)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 2.870" long <u>ml 08/10/11</u> (10)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA613 and Dwg D3353 2- Deburr <u>ml 08/10/11</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 08/10/11</u>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SB 08/10/14</u> (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:33 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 42492

Part Number: D335315

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 *Carl*

8/10/14

(10x)

5p

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40492
Description: Lock Bracket		Part Number: D3353-15
Inspection Dwg: D3353	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype



Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	747	/			
1.20	+/-0.030	1.201	/			
R0.156	+/-0.010	R.156	/			
0.460	+/-0.010	.462	/			
0.80	+/-0.030	.802	/			
0.800	+/-0.010	.797	/			
2.75	+/-0.010	2.751	/			
0.950	+/-0.010	.952	/			
0.254	+/-0.030	.245	/			
1.40	+/-0.030	1.399	/			
0.334	+/-0.010	.333	/			
Ø0.328	+0.006/-0.001	Ø.333	/			
R0.156	+/-0.010	R.156	/			

Measured by: ml
Date: 08/10/12

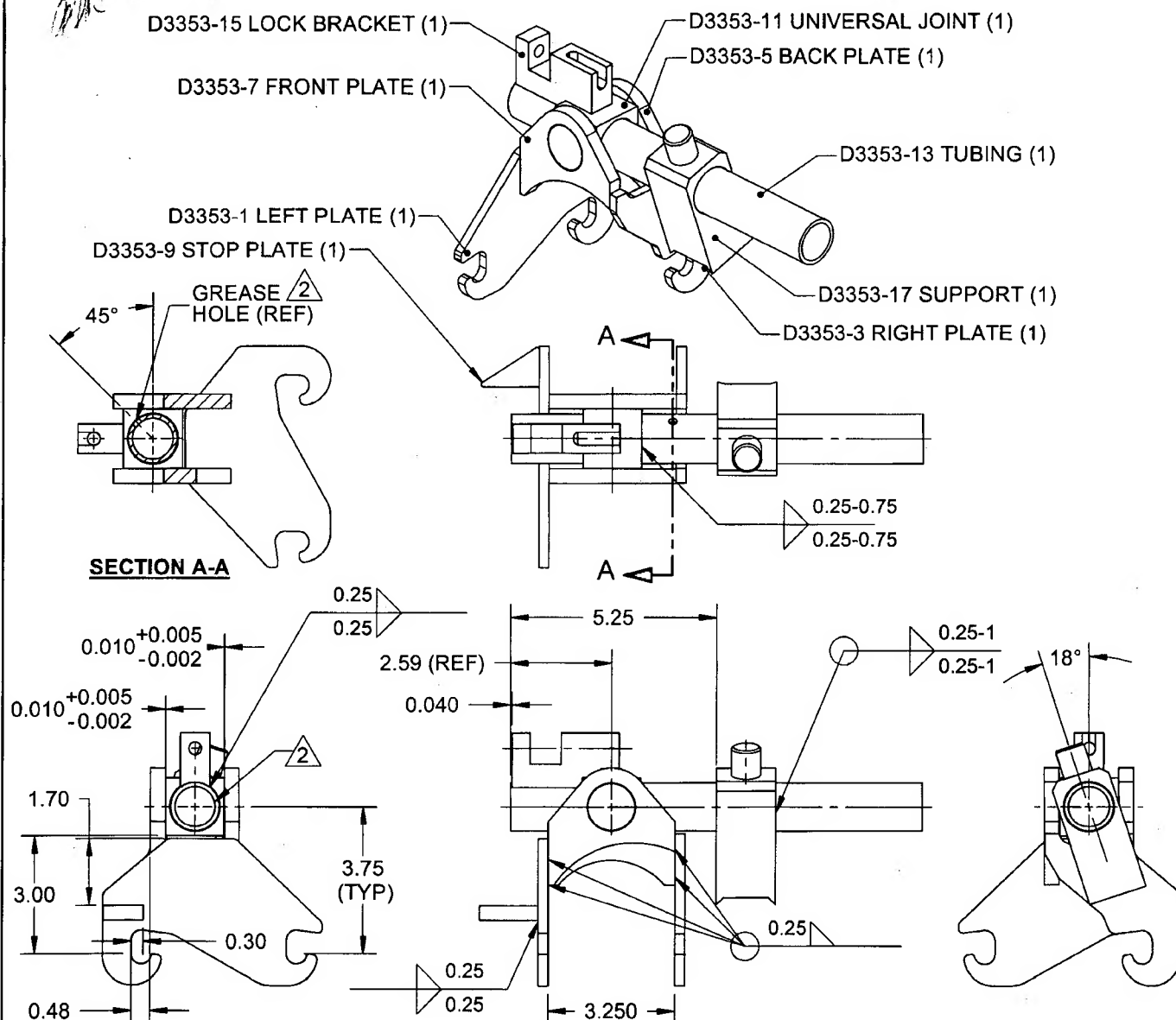
Audited by: SF
Date: 02/10/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	
B	06.12.08	0.501 & 1.20 deep dimensions removed	KJ/EC	EF

DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3353	
DATE 04.12.14		TITLE LUG WELDMENT		REV. A SHEET 1 OF 10 SCALE 1:4	
A	04.12.14	NEW ISSUE			

RELEASED



D3353-041 LUG WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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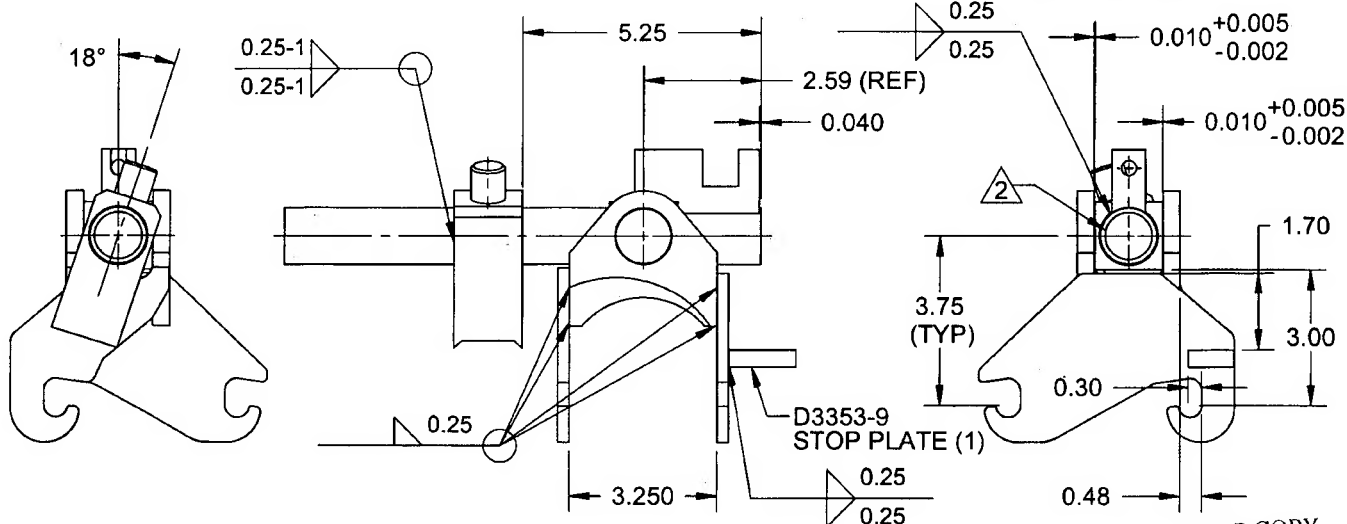
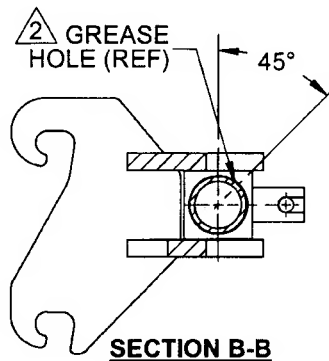
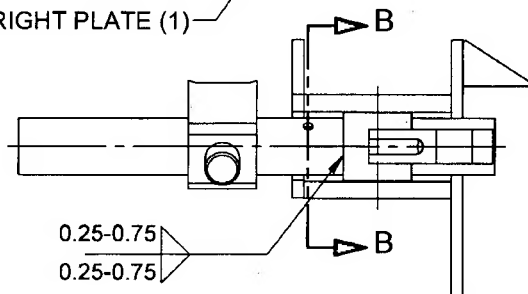
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

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06/03/59

D3353-11 UNIVERSAL JOINT (1)
D3357-5 BACK PLATE (1)
D3353-17 SUPPORT (1)
D3353-13 TUBING (1)
D3353-3 RIGHT PLATE (1)
D3353-15 LOCK BRACKET (1)
D3353-7 FRONT PLATE (1)
D3353-1 LEFT PLATE (1)



D3353-042 LUG WELDMENT

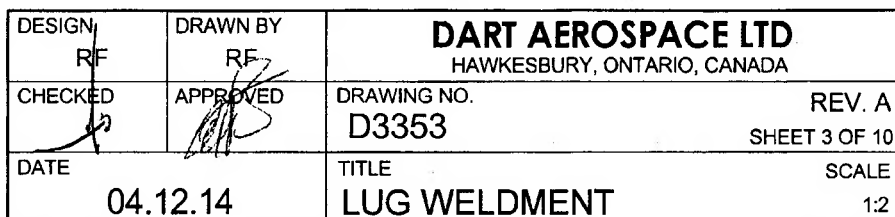
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- 1) WELD PER DART QSI 004
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06/07/69



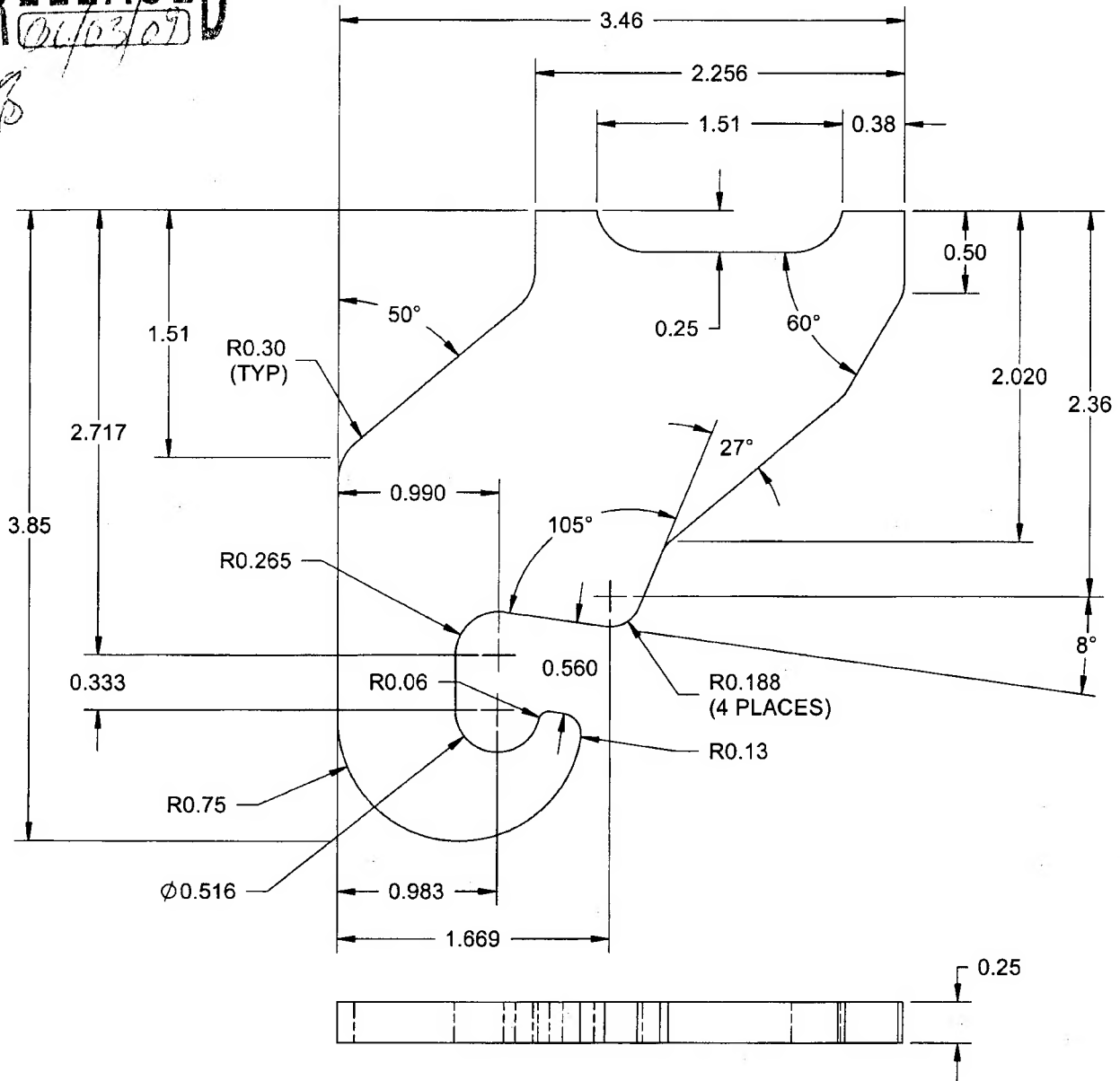
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, NO
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
01/03/07**D3353-3 RIGHT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

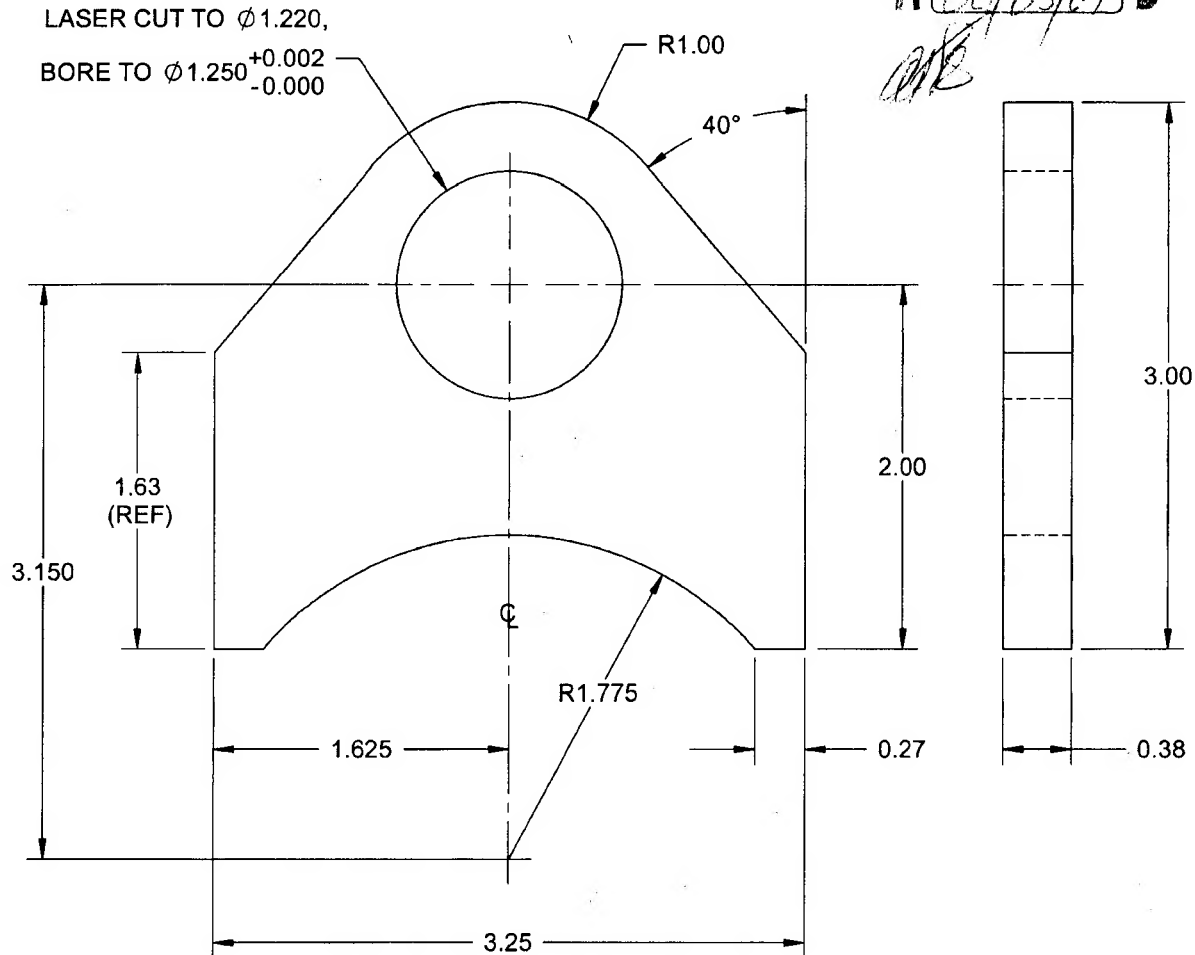
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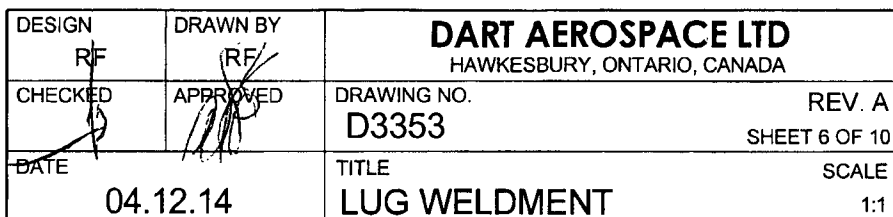
**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

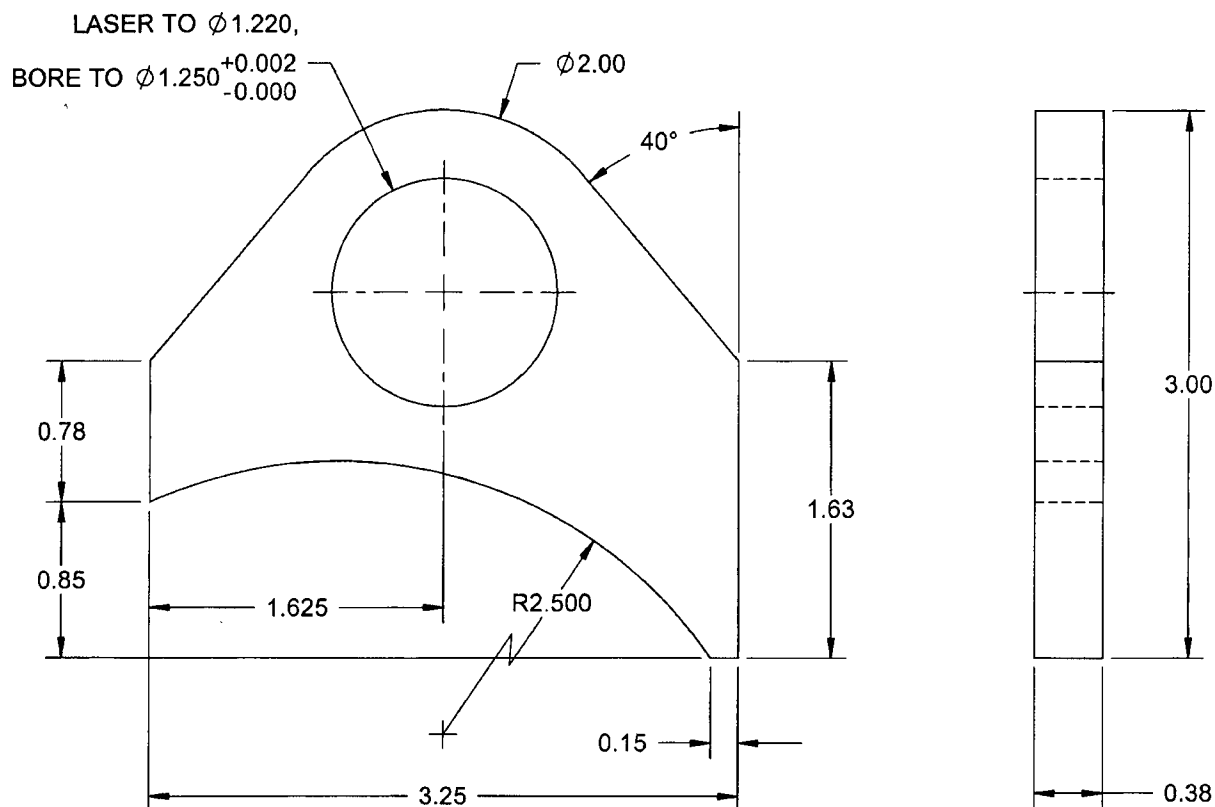
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06/04/07



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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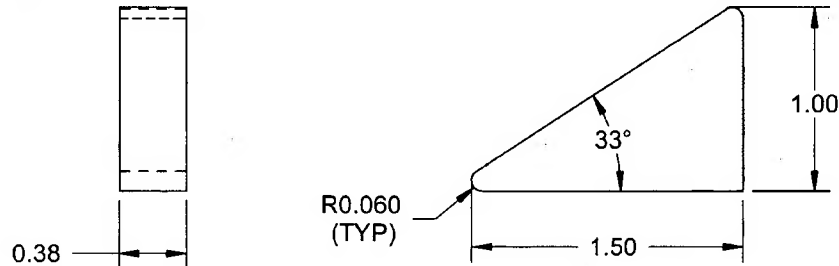
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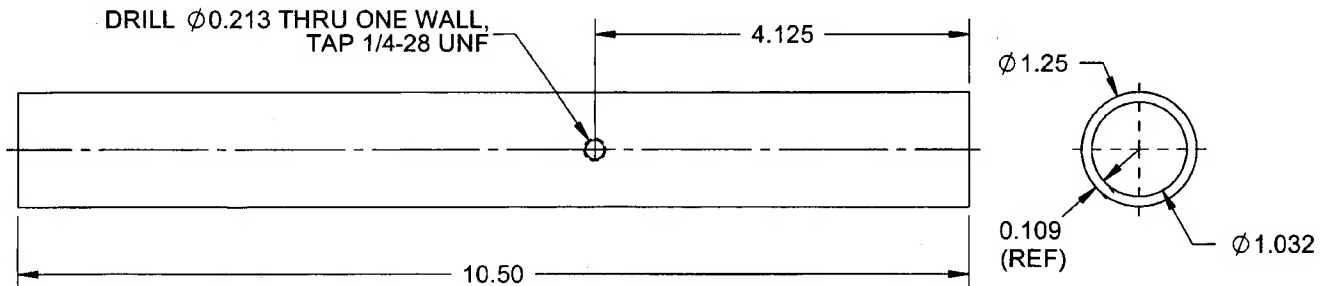
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
3-13-14

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**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

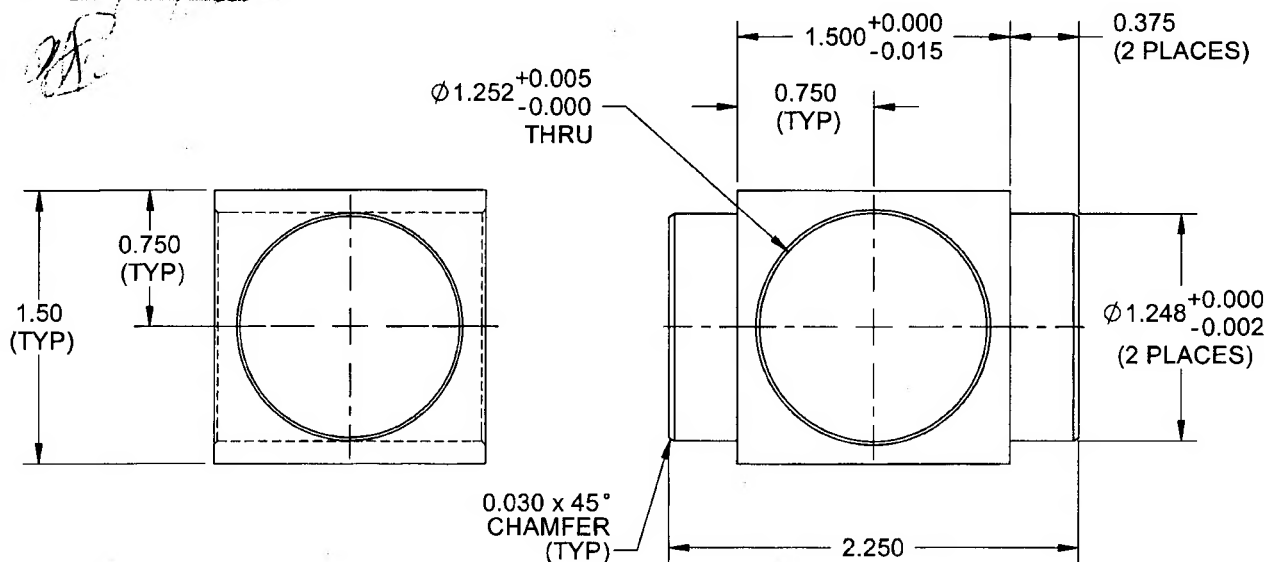
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
06/03/09**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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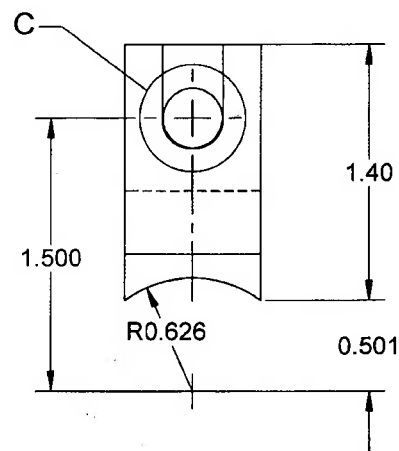
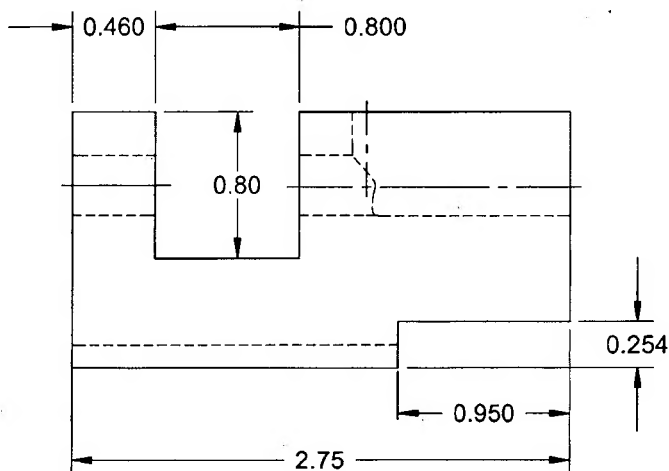
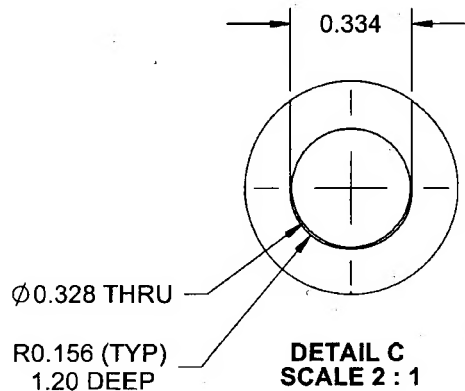
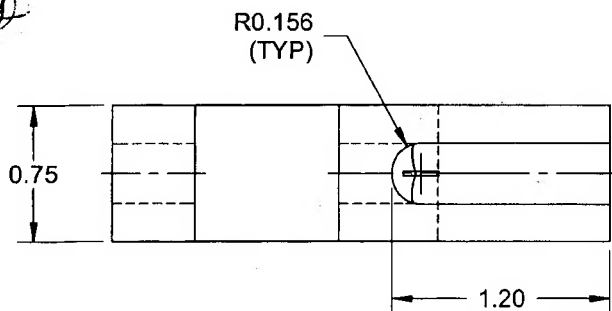
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

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06/22/09

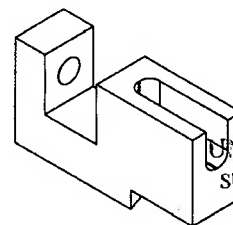
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D3353-15 LOCK BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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ISOMETRIC VIEW
SCALE 1 : 2

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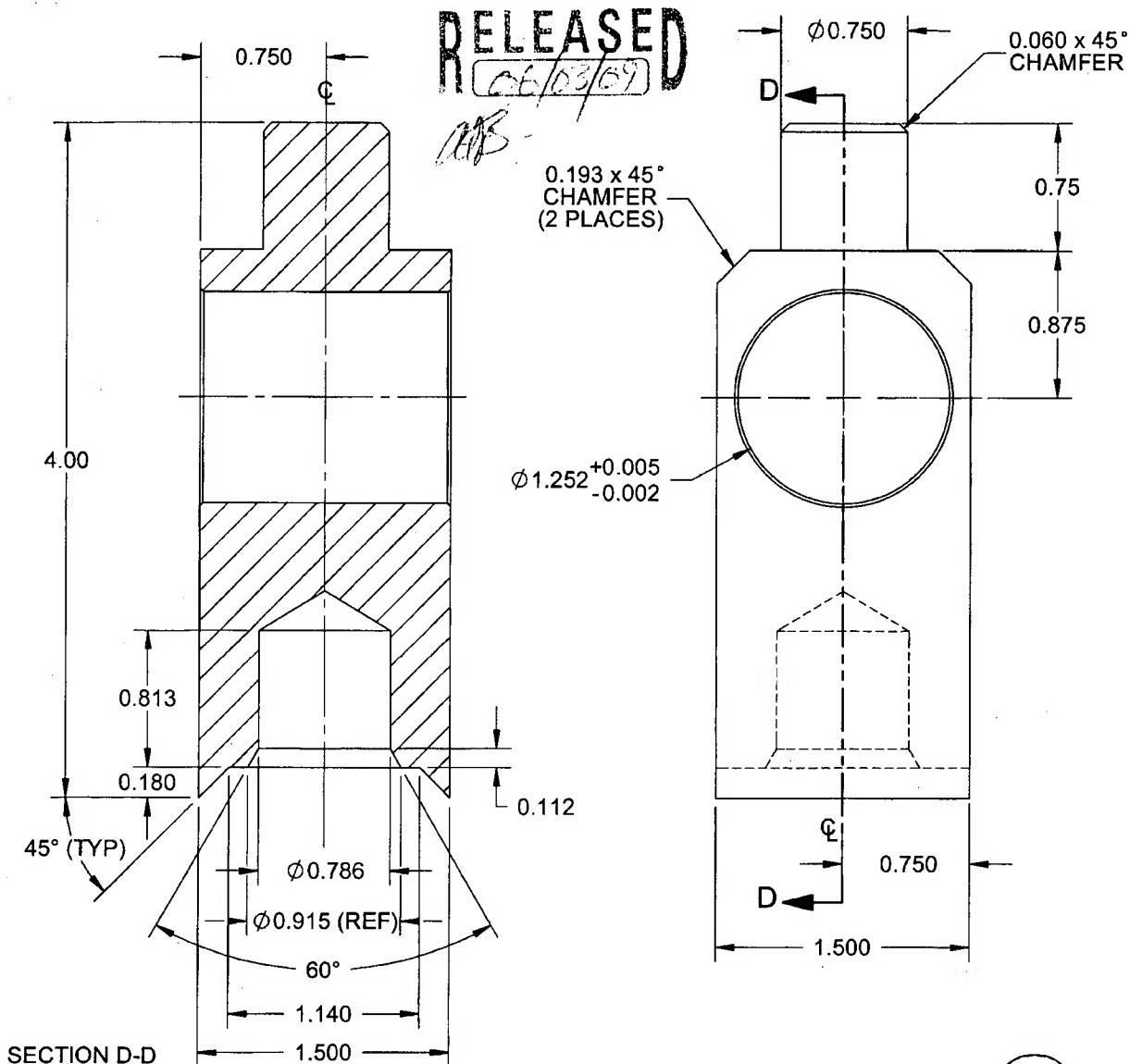
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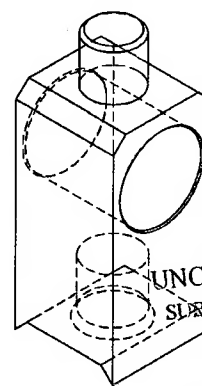
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 10 OF 10 SCALE 1:1



D3353-17 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
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